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Mazdoor Kisan Shakti Sangathan

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“पुराने को छोड़ नये के तरफ़”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6090 (1984): Cam Operated Clamps [PGD 2: Machine Tool Elements and Holding Devices]

“ज्ञान से एक नये भारत का निर्माण”

Satyanaaranay Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartṛhari—Nītiśatakam

“Knowledge is such a treasure which cannot be stolen”



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Indian Standard

SPECIFICATION FOR CAM OPERATED CLAMPS

(First Revision)

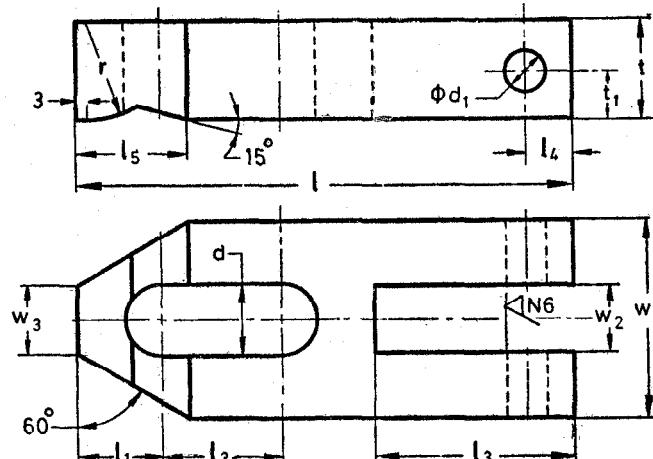
1. Scope — Covers the dimensions of material for cam operated clamps used with cam levers, according to IS : 10882-1984 'Specification for cam levers', in holding workpieces in place when they are being machined.

2. Dimensions — Shall be as given in Table 1.

TABLE 1 DIMENSIONS FOR CAM OPERATED CLAMPS

All dimensions in millimetres.

N11 / (N6)



d H13	d_1 H7	l	l_1	l_3	l_5	l_4	l_6	w_1	w_2	w_3	t	t_1	r	Size of Screw
6.6	6	55	11	12	25	6	14	20	7	6	12	6	12	M6
6.6	6	70	11	25	25	6	14	20	7	6	12	6	12	M6
9	6	70	13	15	30	7	18	25	9	8	14	7	14	M8
9	6	90	13	25	30	7	18	25	9	8	14	7	14	M8
11	6	80	15	20	30	8	20	30	11	10	16	8	16	M10
11	6	90	15	30	30	8	20	30	11	10	16	8	16	M10
14	8	100	17	25	40	10	22	40	13	14	20	10	20	M12
14	8	140	17	60	40	10	22	40	13	14	20	10	20	M12
18	10	125	21	30	50	12	28	50	17	18	25	12	25	M16
18	10	165	21	60	55	12	28	50	17	18	25	12	25	M16

Note — Dimensional deviations for untoleranced dimensions : Coarse class according to IS : 2102 (Part 1) - 1980 'General tolerances for dimensions and form and positions; Part 1 General tolerances for linear and angular dimensions (second revision)'.

3. Designation — A cam operated clamp having $d = 11$ mm and $l = 90$ mm shall be designated as:

Cam Operated Clamp 11 x 90 IS : 6090

4. Material — Steel suitably hardened and tempered to a tensile strength of 750 to 850 N/mm².

5. Finish — The cam operated clamps shall be free from cracks, burrs, pits and other defects. These shall also be free from sharp corners.

6. Preservation and Packing

6.1 A suitable anti-corrosive surface treatment shall be given to the cam operated clamps.

6.2 Cam operated clamps shall be packed in accordance with best trade practice.

7. Marking

7.1 The cam operated clamps shall be marked at an appropriate place with designation, manufacturer's name or trade-mark.

7.2 *ISI Certification Marking* — Details available with the Indian Standards Institution.

EXPLANATORY NOTE

This standard was first published in 1971. The Committee responsible for the formulation of this standard decided to revise it in order to keep it in line with other standards on clamps, which are also being revised, in respect of material, roughness values, tolerance and rationalization of sizes.

In the present revision, the figure in Table 1 has been modified to suit the present practice. Two more sizes of clamps to suit screw size M8 have been included.